

Axial PVC 5009

Rigid Polyvinyl Chloride

Axial Corporation

Message:

Georgia Gulf 5009 is a type I, Grade I rigid vinyl injection molding compound designed for fittings and parts of similar configuration where maximum tensile strength and/or chemical resistance is required. It has full NSF approval and is suitable for all types of water distribution systems, including pressure fittings.

General Information			
UL YellowCard	E53006-243307		
Features	High strength		
	Good chemical resistance		
Uses	Pipe components		
	Piping system		
	Accessories		
Agency Ratings	ASTM D 1784 12454B		
	NSF 14		
UL File Number	E53006		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.39	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.20 - 0.40	%	ASTM D955
PVC Cell Classification	12454-B		ASTM D1784
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2760	MPa	ASTM D638
Tensile Strength	48.3	MPa	ASTM D638
Flexural Modulus	2690	MPa	ASTM D790
Flexural Strength	82.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-20°C, 6.35 mm	32	J/m	ASTM D256
23°C, 6.35 mm	43	J/m	ASTM D256
Dart Drop Impact ¹ (23°C)	36.2	J	ASTM D3029
Drop Impact Resistance (23°C)	116	J/cm	ASTM D4226
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	74.0	°C	ASTM D648
1.8 MPa, not annealed	70.0	°C	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating	V-0		UL 94
Oxygen Index	38	%	ASTM D2863
Additional Information			
Flow Ratio (Distance/Wall Thickness), 390°F: 130			
Injection	Nominal Value	Unit	
Drying Temperature	65.6	°C	
Drying Time	2.0 - 4.0	hr	
Drying Time, Maximum	6.0	hr	
Suggested Shot Size	35 - 75	%	
Suggested Max Regrind	50	%	
Rear Temperature	163	°C	
Middle Temperature	174 - 191	°C	
Front Temperature	182 - 193	°C	
Nozzle Temperature	177 - 193	°C	
Processing (Melt) Temp	202 - 210	°C	
Mold Temperature	15.6 - 48.9	°C	
Injection Pressure	82.7 - 138	MPa	
Holding Pressure	48.3 - 82.7	MPa	
Back Pressure	0.345 - 1.38	MPa	
Screw Speed	25 - 80	rpm	
Clamp Tonnage	3.4	kN/cm ²	
Screw L/D Ratio	16.0:1.0 to 24.0:1.0		
Screw Compression Ratio	1.5:1.0 to 2.5:1.0		
NOTE			
1.	Method f, geometry FB		

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



WECHAT